






Work Order ID 73030



Wednesday, August 24, 2011 10:55:26 AM



Page 1


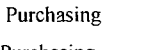
Item ID: D2807-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Door prop
Start Date: 8/24/2011 Start Qty: 30.00  Cust Item ID:
Required Date: 8/29/2011 Req'd Qty: 30.00  Customer:

Reference:


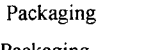
Approvals: Process Plan: CL Date: 11/08/12 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------



Draw Nbr	Revision Nbr
D2807	Rev E

100  PURCHASING 0.00
Purchasing  Memo 0.00
Purchasing Issue P/O: 14734 ☐ Order as per Dwg D2807 ☐ Possible
supplier: Lift Support Technologies, Saskatoon, Canada ☐ P/N 6/15-164/50-115N
☐ Material release note is required

CL 11/08/12 (30)

110  Receive & Inspect for Damage & Mat'l Certs 0.00
Packaging  Memo 0.00
Packaging Ensure Material Release Note is attached

11/8/12 SP (30)

120  QC6- Inspect dimensions to drawing 0.00
QC  Memo 0.00
Quality Control

5/10/09/17

counts
(x30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73030

Wednesday, August 24, 2011 10:55:26 AM

Page 2

Item ID: D2807-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Door prop

Start Date: 8/24/2011 Start Qty: 30.00

Cust Item ID:

Required Date: 8/29/2011 Req'd Qty: 30.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-install D3671-1 as per dwg D2807

EP 11/08/01 30

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

Sulorol

count
(x30)

150

0.00



Packaging

Identify as per dwg & Stock Location: 5122

Memo

0.00

Packaging

(30x) Sp 11-09-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73030

Wednesday, August 24, 2011 10:55:26 AM

Page 3

Item ID: D2807-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Door prop

Start Date: 8/24/2011 Start Qty: 30.00

Cust Item ID:

Required Date: 8/29/2011 Req'd Qty: 30.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/11
MF
11-09201

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 24, 2011 10:55:23 AM

Page 1

Work Order ID: 73030

Parent Item: D2807-041

Parent Item Name: Door prop



Start Date: 8/24/2011

Required Date: 8/29/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP: D 07.11.12 ecn1019, replaces D2807 EC verified by DD
IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
6/15-164/50-115N 		Purchased	No			130	Each	0.0000	1	30			
Gas Spring D3671-1 		Manufactured	No			110	Each	16.0000	1	30			
Placard													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		16							
				71757		6							
				72049		10							

11/8/26 SD (300)
8/31/09/01
6
10
B73033
(14x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

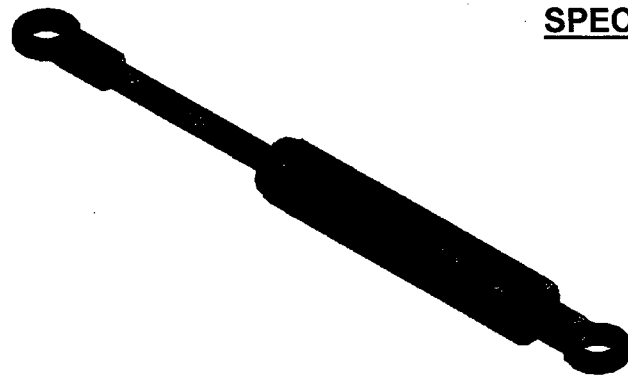
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



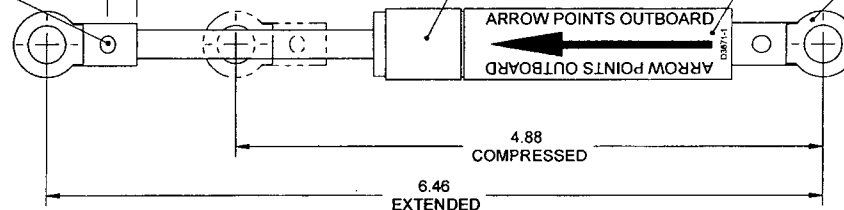
(ALTERNATE ONLY)
CRIMP 0.015-0.025 DEEP
WITH $\varnothing 0.375$ TOOL AT
2000psi (REF) TYP TWO
SIDES PER LUG

0.24 TO CRIMP
(TYP)

D2807-5
OR
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING

(ALTERNATE ONLY) D2807-3
BOTH ENDS



D2807-041 GAS SPRING

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

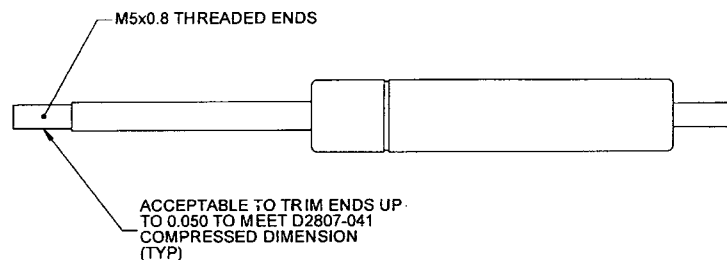
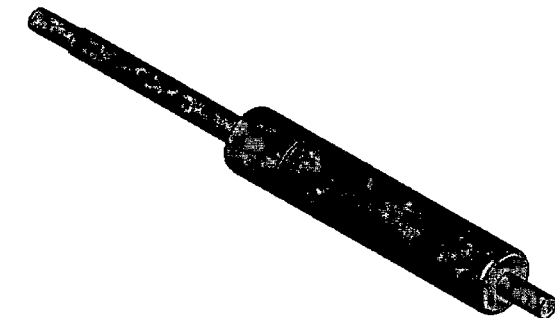
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)
(WEIGHT: 0.176 LBS)

02/11/08/24
W10: 73030

RELEASED
02-11-08

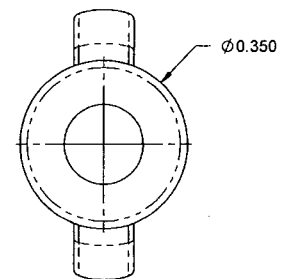
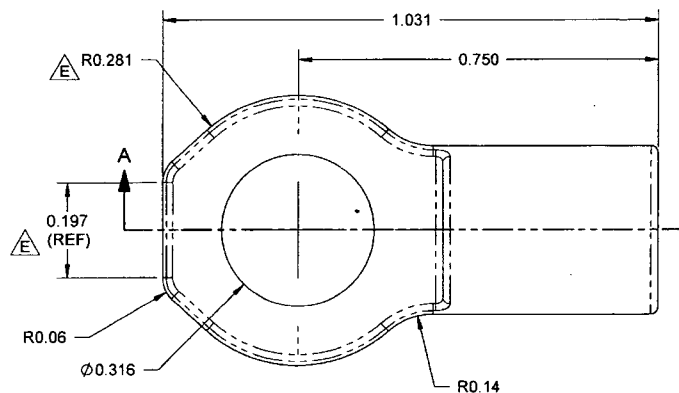
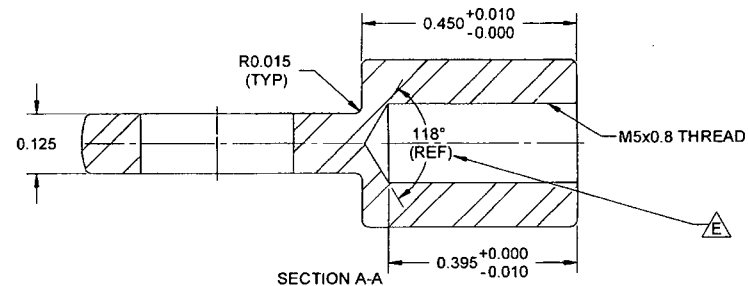
E	ADD D2807-5 GAS SPRING; D2807-1/-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWS	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AE		
CHECKED	KE	DRAWING NO.	REV. E
MFG. APPR.	AE	D2807	SHEET 1 OF 3
APPROVED	AE	TITLE	SCALE
DE APPR.	AE	GAS SPRING	NTS
DATE	07.12.28	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



D2807-1 GAS SPRING
SCALE 1:1

D2807-1 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXF6S6050080S6L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS

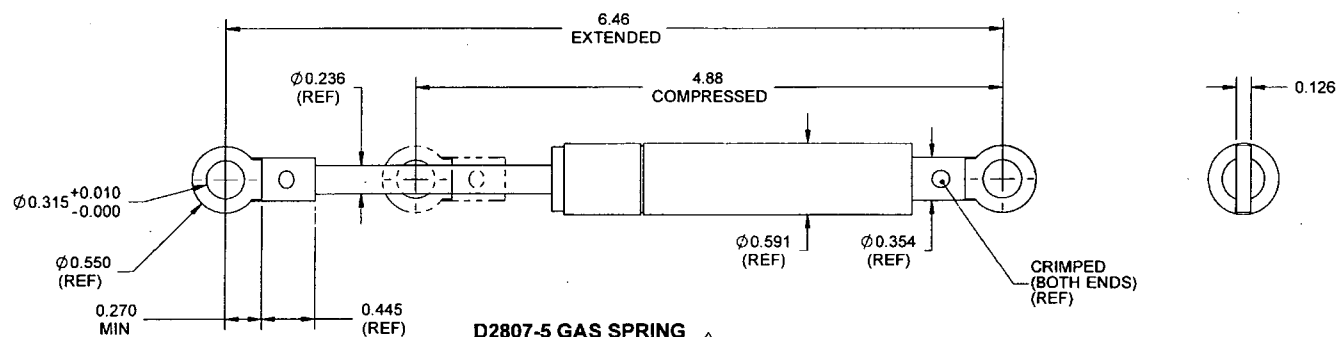
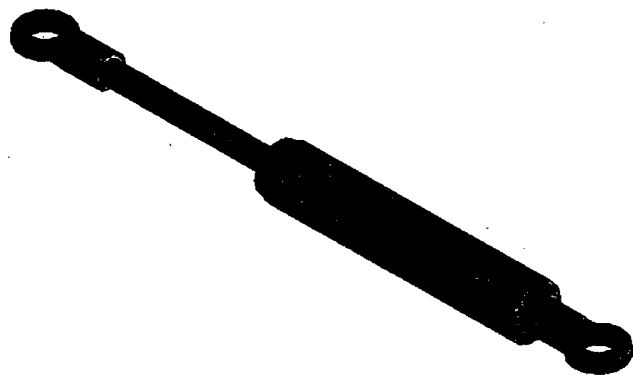


D2807-3 LUG

D2807-3 LUG NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS

DESIGN	HA	DART AEROSPACE LTD	
DRAWN	HA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LF	DRAWING NO.	REV. E
MFG. APPR.	LF	D2807	SHEET 2 OF 3
APPROVED	LF	TITLE	SCALE
DE APPR.	LF	GAS SPRING	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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D2807-5 GAS SPRING

D2807-5 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA (P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS.
ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	KE	DRAWING NO. D2807	REV. E
MFG. APPR.	KE	TITLE GAS SPRING	SHEET 3 OF 3
APPROVED	KE	SCALE 4:1	
DE APPR.	KE	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	07.12.28		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO14734

Purchase Order Date 8/25/2011

PO Print Date 8/25/2011

Page Number 1 of 1

Order From :

VC-LST0001

LS TECHNOLOGIES INC.
303-103 STREET
SASKATOON, SK S7N 1Y9
CA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

306 683 5000

306 683 6403

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA



Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	6/15-164/50-115N	Gas Spring	8/29/2011 Yes	30.00 Each	FedEx PI collect	\$63.9000	\$1,917.00

11/6/2011
SP

Special Inst: AS PER DWG D2807 REV. E
B73030

PO Total:

\$1,917.00

CERTIFICATE OF CONFORMITY
REQD UPON DELIVERY

Change Nbr: 1

Change Date: 8/25/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

LS Technologies Canada Inc.

303 - 103 Street
Saskatoon, SK Canada
S7N 1Y9

Packing Slip

Date	Invoice #
8/25/2011	7625

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

P.O. No.	Ship	Via	FOB	Project
PO14734	8/25/2011	Fed-Ex		

Qty	Description
30	D2807 Stainless Gas Spring (6/15-164/50-115N) Shipping Via FED EX Tracking #797450426167
11/6/26	



303 – 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

August 25, 2011

This is to certify that the parts listed below meets specifications as required by your order.

30 Units: D2807 Stainless Gas Spring (6/15-164/50-115N)

Country of Manufacture : Canada
Date of Manufacture : August, 2011
This product is ROHS compliant.

6/15/11

Purchase Order # 14734

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read "Nolan Fehr", written over a horizontal line.

Nolan Fehr
President